

Work Order ID 70072-2

Thursday, May 26, 2011 10:29:37 AM

Page 1

Item ID: D2360

Revision ID:

Item Name: Litter Tie Down Assembly

Start Date: 5/26/2011 Start Qty: 6.00

Required Date: 6/3/2011 Req'd Qty: 6.00

Reference:

Approvals:

Process Plan:

Date: 11/05/06 Tooling:

Date:

Run Start

QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2341	Rev F								
D2360	Rev D								

100



Bandsaw

Jeaspa Bandsaw

BAND SAW

Memo

Cut blanks: 12.65" Long

0.00

0.00

on 11/06/00

6

110



HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

Machine as per Folio D2341 and Dwg D2341
2-Deburr

0.00

0.00

on 11/06/13

6

SPLIT

ASAP

3



Accept



Setup Start

Stop

Cust Item ID:

Customer:



Work Order ID 70072

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Page 2

Item ID: D2360

Accept



Setup Start



Revision ID:

Item Name: Litter Tie Down Assembly

Stop



Start Date: 5/26/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 6/3/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

OK 11/06/13

6

~~0~~

Quality Control

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

SL 11/06/14

6

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

6

6

11/06/14

Hand Finishing

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Item ID: D2360

Accept



Setup Start



Revision ID:

Item Name: Litter Tie Down Assembly

Stop



Start Date: 5/26/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 6/3/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

0.00

6X ~~φ~~ M-11/06/15

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

6 ~~φ~~ M-11/06/15

170

Small Fab

0.00



Small Fab

Memo

Assemble as per dwg D2360

0.00

Small Fab

E-11/06/28 (3)

Work Order ID 70072

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Page 4

Item ID: D2360

Accept



Setup Start



Revision ID:

Item Name: Litter Tie Down Assembly

Stop



Start Date: 5/26/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 6/3/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC5- Inspect part completeness to step on W/O

0.00

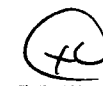


QC

Memo

0.00

8 w/06/28



Quality Control

190

Identify as per dwg & Stock Location: ST 224

0.00



Packaging

Memo

0.00

Packaging



JB (3)

11/06/29

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/5

MF

6-06-29

Picklist Print

Thursday, May 26, 2011 10:29:47 AM

Page 1

Work Order ID: 70072

Parent Item: D2360

Parent Item Name: Litter Tie Down Assembly

Start Date: 5/26/2011

Start Qty: 6.00

Required Date: 6/3/2011

Required Qty: 6.00

Comments: IPP rev H 07.06.12 ecn 825 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6201		Manufactured	No			100	f	8.0000	1.054	6.656842			



"T" Extrusion

Location

Loc Qty

Loc Code

MAT004

8

57767

8

AN526C1032R18

Purchased

No

170

Each

675.0000

1



Screw

Location

Loc Qty

Loc Code

FP-B

93

4523

93

ST328

582

101458

59

108079

419

110099

100

4523

4

AN960JD10

NAS1149D0363J Purchased

No

170

Each

0.0000

2



Washer

4DM117291

12x

AN960JD10L

NAS1149D0332J Purchased

No

170

Each

0.0000

8



Washer

4DM117291

48x

6.66 11/06/10
6
EP 11/06/28

2
4
12
EP 11/06/28
48
EP 11/06/28

Picklist Print

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Page 2

Work Order ID: 70072

Parent Item: D2360

Parent Item Name: Litter Tie Down Assembly

Start Date: 5/26/2011

Required Date: 6/3/2011

Start Qty: 6.00

Required Qty: 6.00

D2002-015

Manufactured No

170

Each

35.0000

2

12



Knob

Location

Loc Qty

Loc Code

~~MEZZ~~

35

35

D2345

Manufactured No

170

Each

0.0000

1

6



Lock Channel

D2366

Manufactured No

170

Each

17.0000

2

12



Lock Handle

Location

Loc Qty

Loc Code

ST012

17

66512

17

D2367

Manufactured No

170

Each

21.0000

1

6



Handle Knob

Location

Loc Qty

Loc Code

ST011

20

68883

20

ST012

1

57764

1

D2372

Manufactured No

170

Each

30.0000

2

12



Quick Release

Location

Loc Qty

Loc Code

ST012

30

57765

2

60716

28

EP 5/11/06/28

EP 5/11/06/28

EP 5/11/06/28

EP 5/11/06/28

Picklist Print

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Work Order ID: 70072

Parent Item: D2360

Parent Item Name: Litter Tie Down Assembly

Start Date: 5/26/2011

Required Date: 6/3/2011

Start Qty: 6.00

Required Qty: 6.00

D2373
Spring
Manufactured No

170 Each 21.0000 1



6
EP 11/06/28

Location

Loc Qty

Loc Code

ST012

21

42920

1

66118

20

170 Each 0.0000 1



6
EP 11/06/28

D2444
Pip Pin Assembly
Manufactured No

MS20470AD3-4
Rivet, Universal Head
Purchased No

170 Each 9,162.000 1



6
EP 11/06/28

Location

Loc Qty

Loc Code

ST319

9162

111477

8332

15541

830

170 Each 2,168.000 3



18
EP 11/06/28

MS21042L3
Nut
Purchased No

Location

Loc Qty

Loc Code

ST300

2168

116391

11

116540

191

116549

766

117441

800

117601

400

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Shop Packet Print

Page 3

Picklist Print

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Page 4

Work Order ID: 70072

Parent Item: D2360

Parent Item Name: Litter Tie Down Assembly



Start Date: 5/26/2011

Required Date: 6/3/2011

Start Qty: 6.00

Required Qty: 6.00

MS27039-1-13 Purchased

No

170

Each

44.0000

1



Screw

Location

Loc Qty

Loc Code

ST292

44

110844

44

MS27039-1-15 Purchased

No

170

Each

74.0000

2



Screw

Location

Loc Qty

Loc Code

ST292

74

116916

74

NAS679A3W Purchased

No

170

Each

219.0000

1



Nut

Location

Loc Qty

Loc Code

~~MEZZ~~

219

G-A

1463

26

2409

193

6
EP 5/11/06/28

6
12
EP 5/11/06/28

12
6
EP 5/11/06/28

6

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Shop Packet Print

Page 4

DART AEROSPACE LTD		Work Order:	70072
Description: Litter Tie Down Bracket (Locking)		Part Number:	D2341
Inspection Dwg: D2341	Rev: F	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.750	+/-0.010	1.748	✓		Vern ML-2	
2.75	+/-0.030	2.752	✓		"	
Ø0.242	+0.005/-0.001	Ø0.243	✓		"	
Ø0.191	+0.005/-0.001	Ø0.192	✓		"	
R0.25	+/-0.030	R.250	✓		R-G	
R0.40	+/-0.030	R.400	✓		"	
12.50	+/-0.030	12.500	✓		M-type ML-2	
11.750	+/-0.010	11.750	✓		"	
11.00	+/-0.030	11.000	✓		"	
7.00	+/-0.030	7.000	✓		"	
6.250	+/-0.010	6.250	✓		"	
5.50	+/-0.030	5.50	✓		"	
1.50	+/-0.030	1.50	✓		Vern ML-2	
0.750	+/-0.010	0.746	✓		"	
0.400	+/-0.010	0.400	✓		Vern ML-2	
1.584	+/-0.010	1.583	✓		"	
2.610	+/-0.010	2.610	✓		"	
0.250	+/-0.010	0.250	✓		"	
0.844	+/-0.010	0.844	✓		"	
Ø0.250	+/-0.010	Ø0.251	✓		"	
0.750	+/-0.010	0.753	✓		"	
3.313	+/-0.010	3.315	✓		"	
4.250	+/-0.010	4.250	✓		"	
1.250	+/-0.010	1.246	✓		"	

Measured by:	amf
Date:	11/06/13

Audited by:	SL
Date:	11/06/13

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.05.24	New Issue P/O D2360	KJ/JLM	
B	07.07.17	Dwg Rev. updated	KJ/JLM	
C	10.02.02	Dimensions updated	KJ	



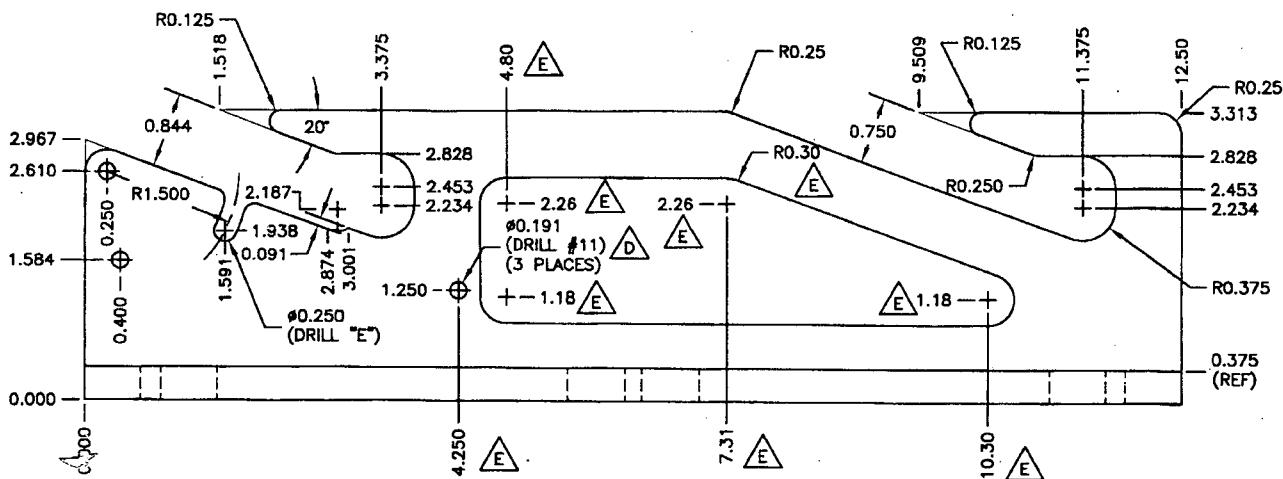
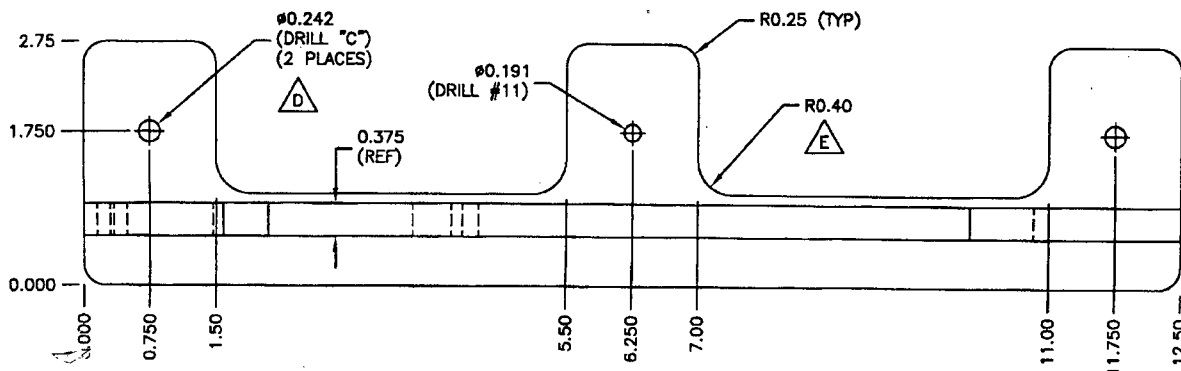
SHOP COPY

RETURN TO:

ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 70072

6114 CS 26

DESIGN BW	DRAWN BY JC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JB	APPROVED JH	DRAWING NO. D2341	REV. F SHEET 1 OF 1
DATE 07.06.07		TITLE LITTER TIE DOWN BRACKET (LOCKING)	SCALE 1:2
A	95.01.13	NEW ISSUE	
B	95.02.14	MODIFIED LOCK	
D	95.02.20	CHANGES TO DIAMETERS	
E	97.10.01	CHANGES FOR MACHINING	
F	07.06.07	REVISED NOTES; FINISH WAS ANODIZE	



D2341 LITTER TIE DOWN BRACKET (LOCKING)

- 1) MATERIAL: MAKE FROM D6201-D125 EXTRUSION
(6061-T6/T651 PER QQ-A-200/B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (REF. 4.3.5.1) PER QSI 005 4.3
- 3) BREAK ALL SHARP EDGES TO 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N "D2341" USING FINE POINT
PERMANENT INK MARKER



RELEASED

07-6-22

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DART

DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CE	APPROVED HA	DRAWING NO. D2360	REV. D SHEET 1 OF 2
DATE 07.06.06		TITLE LITTER TIE DOWN ASSEMBLY (LOCKING) NTS	
A	95.02.10	NEW ISSUE	
B	95.02.20	RE-DESIGN	
C	97.08.27	ADD MS20470AD3-4 RIVET	
D	07.06.06	D2002-015 WAS D2376; SECTION B-B QTY(2) AN960JD10 WAS QTY(3) QTY(8) AN960JD10L WAS QTY(5)	

RELEASED

07.06.07

u/b 70072

PARTS LIST:

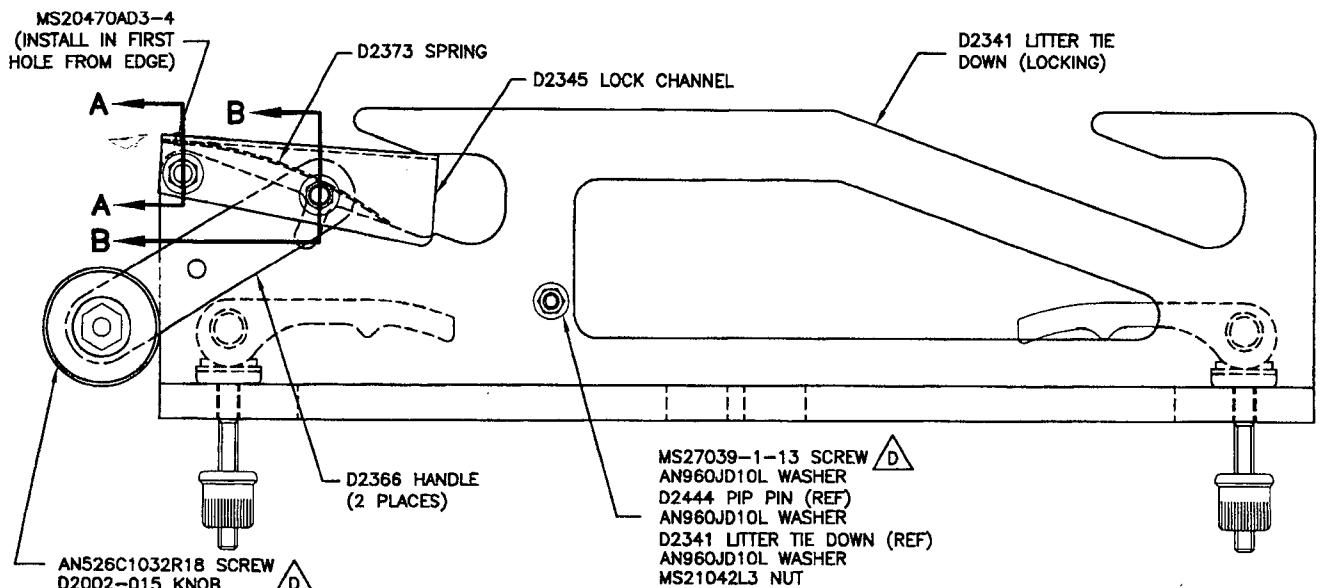
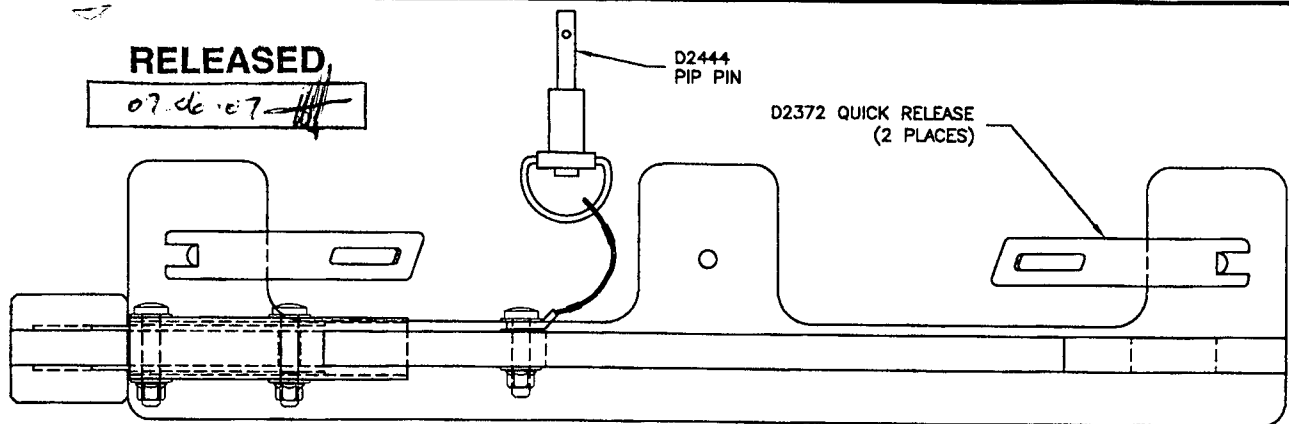
QTY	PART NUMBER	DESCRIPTION
X	D2360	LITTER TIE DOWN ASSEMBLY (LOCKING)
1	D2341	LITTER TIE DOWN (LOCKING)
1	D2345	LOCK CHANNEL
2	D2366	LOCK HANDLE
1	D2367	KNOB (DELRIN)
2	D2372	QUICK RELEASE FASTENERS
1	D2373	SPRING
2	D2002-015	KNOB (DELRIN)
1	D2444	PIP PIN
1	AN526C1032R18	SCREW
2	AN960JD10	WASHER
8	AN960JD10L	WASHER
1	MS20470AD3-4	RIVET
3	MS21042L3	NUT (OR MS21042-3)
1	MS27039-1-13	SCREW
2	MS27039-1-15	SCREW
1	NAS679A3W	NUT

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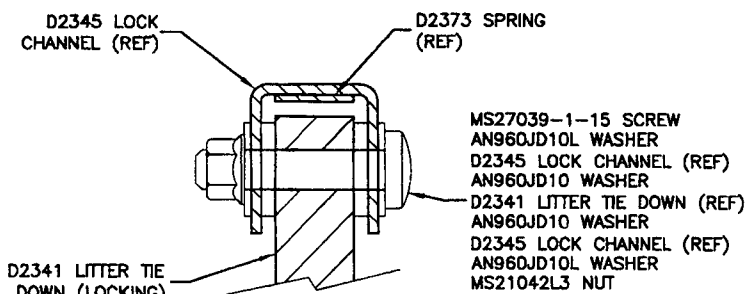
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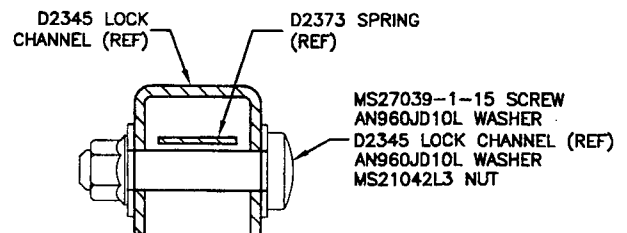
DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED H	DRAWING NO. D2360	REV. D SHEET 2 OF 2
DATE 07.06.06		TITLE LITTER TIE DOWN ASSEMBLY (LOCKING) NTS	SCALE



D2360 LITTER TIE DOWN ASSEMBLY (LOCKING)



SECTION A-A
(SCALE 1:1)



SECTION B-B
(SCALE 1:1)

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